the mould with a continuous free edge, and applying the free edge of the mold directly to the lens blank supportive face to form a tight seal therebetween.

2. A method as claimed in claim 1, in which in the molding of the lens blank a sealing member is interposed between the casting dies, the sealing member having a plane surface which is in contact with the casting die corresponding to said at least one lens blank face, the last mentioned casting die has a plane facet having a radial dimension at all points thereof such that the plane facet extends radially inwardly of the sealing member.

3. A method of making ophthalmic lenses having a progressively variable focal power, comprising the steps of molding a blank of organic material having on at least one of its faces an active zone of progressive variable radius of curvature and a continuous annular marginal zone extending around the entire active zone and defining a combined sealing and support surface, bringing a gripper block mold having a free sealing edge into position over the active zone of said one face and placing the free sealing edge of the mold into direct sealing engagement with said combined sealing and support surface to provide fluidtight contact therebetween, introducing low melting point material into the mold to form on said one face of the lens blank a gripper block for holding the same during machining, machining the other face of the lens blank to the desired profile and then melting the gripper block from the machine lens.

4. A method as claimed in claim 3, wherein said combined support and sealing surface is formed to be of variable radial extent but at all points to be equal to or greater than the radial extent of the free sealing edge of the mold.

5. A method as claimed in claim 4, wherein the support and sealing surface is formed to be generally plane.

6. A method as claimed in claim 4, wherein the support and sealing surface is formed to be part spherical.

7. A method as claimed in claim 4, wherein the support and sealing surface is formed to be part conical.

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